

Date: Wednesday, 02/04/2008 3:38:49 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACERS (5/16 THICK)
Job Number :	38329		
Estimate Number :	10248		
P.O. Number :		Part Number :	D2022103
This Issue :	02/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2022 REV. --
First Issue :	//	Project Number :	N/A
Previous Run :	35885	Drawing Revision :	--
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/04/2008
Written By :		Qty:	100
		Um:	Each
Checked & Approved By :	JD 08.04.03		
Comment :	Est D 02.03.07 Now made in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total : 3.2865 f(s)

6061T6 Round Bar .750"

Material: 6061-T6 (QQ-A-225/8)x.7500 bar

(M6061T6R0.750)

Batch: M103857

J.F. 08/04/19

(112)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1- Note: .323 (P) Dia drill.

2-Turn Blank as per FolioFA207

3-Tumble & deburr any sharp edges as per dwg

J.F. 08/04/19

(112)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/04/19

(112)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

RQ 08/04/21

(112)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 9

AS 08/04/21

(x112)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (5/16 THICK)

Job Number: 38329

Part Number: D2022103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-04-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

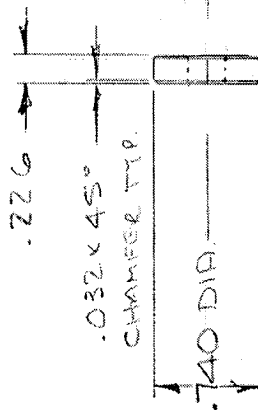
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
R 170114 BW



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (20-D-225/E)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38329

D2022-103		SPACER 5/16 ALUM 6061-T6		30-D-250/B	
D2022-101		SPACER 1/4 ALUM 6061-T6		30-D-250/B	
PART NO.		ITEM		DESCRIPTION	
CONTRACT NO.		DATE		CLIENT	
DESIGN		DESIGN		TITLE	
STYLES		STYLES		CODE	
CHECKED		CHECKED		CLIENT	
APPROVAL		APPROVAL		DATE	
BASIC CODE		BASIC CODE		BASIC CODE	
DRAWING & PARTS		DRAWING & PARTS		DRAWING & PARTS	
EXPLANATION		EXPLANATION		EXPLANATION	
TOLERANCES - AS & B		TOLERANCES - AS & B		TOLERANCES - AS & B	
ANGLES - AS & B		ANGLES - AS & B		ANGLES - AS & B	
SURFACE FINISH - 011 MAX		SURFACE FINISH - 011 MAX		SURFACE FINISH - 011 MAX	
ELECTROPLATING - 001 MAX		ELECTROPLATING - 001 MAX		ELECTROPLATING - 001 MAX	
ALL DIMENSIONS IN INCHES		ALL DIMENSIONS IN INCHES		ALL DIMENSIONS IN INCHES	
REPORT ALL DISCREPANCIES - DO NOT SCALE		REPORT ALL DISCREPANCIES - DO NOT SCALE		REPORT ALL DISCREPANCIES - DO NOT SCALE	
REVISION		REVISION		REVISION	
DRAWN		DRAWN		DRAWN	
APPROVED		APPROVED		APPROVED	
DESCRIPTION		DESCRIPTION		DESCRIPTION	
OF		OF		OF	
CHANGE		CHANGE		CHANGE	
DART AERO ACCESSORIES INC		DART AERO ACCESSORIES INC		DART AERO ACCESSORIES INC	
SPACERS		SPACERS		SPACERS	
D2022		D2022		D2022	
DATE		DATE		DATE	
SHEET		SHEET		SHEET	